



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

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D3913-041
Job Sheet 184500



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/10/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/9/18	0.00	0.00	Start Up Large Fab-5		18-11-13
100	Large Fab	1 pcs		11/9/18	0.00	10.00	Large Fab 1		18-11-13
110	QC	1 pcs		11/9/18	0.00	0.00	QC9		18-11-13
120	QC	1 pcs		11/9/18	0.00	0.00	QC5		18-11-13
125	HandFinish	1 pcs		11/9/18	0.00	0.29	HandFinish2		18-11-13
130	Powdercoat	1 pcs		11/9/18	0.00	0.93	Powdercoat2		18-11-13
135	Packaging	1 pcs		11/9/18	0.00	0.00	Packaging1		18-11-13
140	QC	1 pcs		11/9/18	0.00	0.00	QC3		18-11-13
150	HandFinish	1 pcs		11/9/18	0.00	0.50	HandFinish4		18-11-13
160	QC	1 pcs		11/9/18	0.00	0.00	QC5		18-11-13
170	Packaging	1 pcs		11/9/18	0.00	0.00	Packaging3-2		18-11-13
180	QC21-SA	1 Ea		11/9/18	0.00	0.00	QC21		18-11-13

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

M 138951. 2:35. START 375°. O.V.T. 328 FINISH 2:50.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	S 105 222
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	S 112 746
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	S 108 592
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	S 112 730
D3913-7	Rib	2 Ea (2 ea)	90-Start up Operation	S 115 925
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	S 116 572
D3916-041	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	S 122 708
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	S 117 380
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	S 115 309
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	S 110 037
D4017-9	Rib	2 Ea (2 ea)	90-Start up Operation	S 115 755

06/67

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

D4020-11	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation
D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish
D2931	Bumper	2 Ea (2 ea)	150-HandFinish
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish
D4021-5	Blanking Plate	2 Ea (2 ea)	150-HandFinish

5109707
 5108590
 5116607
 5116607
 5114035
 5093684
 5106952
 506435
 5076007
 5094592
 5109991
 5108637

Job Allocations

666472

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	70	0
	D3913-1	1	6	0
	D3913-15	1	22	0
	D3913-3	1	7	0
	D3913-7	2	24	0
	D3913-9	1	13	0
	D3916-041	2	8	0
	D3916-5	3	6	0
	D4016-1	3	193	0
	D4017-7	3	25	0
	D4017-9	2	24	0
	D4020-11	2	17	0
	D4021-1	3	41	0
	D4034-041	1	6	0
	D4034-043	1	6	0
	D4672-1	2	16	0
	M304EX0.75-16F	33	1,319	0
	AN3-10A	6	210	0
	D2931	2	946	0
150-HandFinish	D4021-5	2	32	0
	MS20600-AD4W3	2	337	0
	MS21042L3	6	2,863	0
	NAS1149F0332P	12	2,943	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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